

AS 350

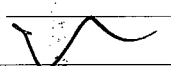
Work Order ID 119957

\*119957\*


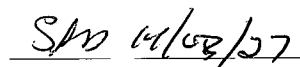
Page 1


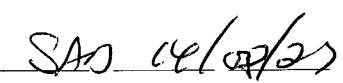
June-02-14 8:07:51 AM

Item ID: 646.3001      Accept      \*N900040100\*      Setup Start \*NS1\*  
Revision ID:      Stop \*NS2\*  
Item Name: Lower Cutter Assy  
Start Date: 6/02/14      Start Qty: 2.00      \*2\*      Cust Item ID:  
Required Date: 6/03/14      Req'd Qty: 2.00      \*2\*      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start \*NR1\*  
QC:       Date:      SPC (Y/N):      Date:      Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
646.3000	N/C								

110      Pick Kit      0.00  
**\*110\***              
Packaging      Memo      0.00  
Packaging

120      0.00  
**\*120\***              
Small Fab      Memo      0.00  
Small Fab      Assemble as per dwg and apply loctite 598 on all faying surfaces shown on dwg per note 7.  
A/R RTV LOCTITE 598: M127443  
exp. date: oct 2015

# Picklist Print

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Work Order ID: 119957

**\*119957\***

Parent Item: 646.3001

**\*646.3001\***

Parent Item Name: Lower Cutter Assy

Start Date: 6/02/14

Required Date: 6/03/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MS21042L08

Purchased

No

Each

5,386.000

38 ~~20~~ ?  
SAD 14/08/27

**\*MS21042L 08\***

Nut

Location

Loc Qty

Loc Code

ST314

3429

123900

58

m128401

1500

m128429

1871

ST508

1858

125445

460

m127410

1398

20

ST509

99

m127304

99

646.3010

Manufactured

No

110

Each

5.0000

1

2

**\*646.3010\***

LH Half

\*\*

SAD 14/08/27

Location

Loc Qty

Loc Code

CA

5

117211

5

6B/20554

2

646.3011

Manufactured

No

110

Each

10.0000

1

2

**\*646.3011\***

RH Half

\*\*

SAD 14/08/27

Location

Loc Qty

Loc Code

CA

1

99787

1

1

MF

9

110640

1

113799

8

2

# Picklist Print

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Work Order ID: 119957

**\*119957\***

Parent Item: 646.3001

**\*646.3001\***

Parent Item Name: Lower Cutter Assy

Start Date: 6/02/14

Required Date: 6/03/14

Start Qty: 2.00

Required Qty: 2.00

646.3012

Manufactured No

110

Each

15.0000

1

2

**\*646.3012\***

Lower Guide

\*\*

SAD 14/08/27

Location

Loc Qty

Loc Code

CA

3

102843

3

MF

12

110629

5

113655

7

2

646.3013

Manufactured No

110

Each

22.0000

1

2

**\*646.3013\***

Blade

\*\*

SAD 14/08/27

Location

Loc Qty

Loc Code

CA

22

102802

5

106687

4

108183

4

110624

1

113622

8

2

646.3014

Manufactured No

110

Each

17.0000

1

2

**\*646.3014\***

Blade

\*\*

SAD 14/08/27

Location

Loc Qty

Loc Code

CA

17

102901

1

107626

4

109914

12

2

# Picklist Print

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Work Order ID: 119957

Parent Item: 646.3001

Parent Item Name: Lower Cutter Assy

**\*119957\***

**\*646.3001\***

Start Date: 6/02/14

Required Date: 6/03/14

Start Qty: 2.00

Required Qty: 2.00

646.3015 Manufactured No

110 Each

32.0000

1

2

**\*646.3015\***

Blade

\*\*

SAD 14/02/27

Location

Loc Qty

Loc Code

CA

32

107339

21

107664

9

93344

2

2

MS27039-08-19

Purchased No

110 Each

2,238.000

19

38

**\*MS27039-08-19\***

Screw

\*\*

SAD 14/02/27

Location

Loc Qty

Loc Code

ST506

2238

124309

836

125654

127

m127410

275

m127904

1000

38

NAS1149FN832P

Purchased No

110 Each

9,794.000

38

76

**\*NAS1149FN832P\***

Washer

\*\*

SAD 14/02/27

Location

Loc Qty

Loc Code

ST295

470

123185

30

123522

400

123900

40

st510

9324

125268

9324

38

76

NOTES:

- ① MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- ② FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;  
CARDINAL 4860-50 PRETREATMENT PRIMER  
PRIME IAW MIL-P-23377J TYPE I CLASS N
- ③ MATERIAL: AISI A2 TOOL STEEL  
CONDITION: ANNEALED  
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- ④ FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N
5. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
6. IDENTIFY IAW MPP-120
- ⑦ APPLY F/N 11 AS REQUIRED TO ALL FAYING SURFACES OF F/N 4, 5 & 6 UPON ASSEMBLY
- ⑧ CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE

17PL10

7 9

646.3001  
SHOWN EXPLODED

UNINCORPORATED ECN(S)

02195

[illegible]

